

304, 500

Work Order ID 69894



Page 1

Tuesday, May 24, 2011 10:07:29 AM

Item ID: D2537

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 5/24/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11-05-24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2537

Rev A1

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Machine as per Folio FA273□2-Deburr and Tumble

SA 11/6/7

300 0

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SA 11/6/7

300 0

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

RA 11.6.7

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69894

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Page 2

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Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging	Identify as per dwg & Stock Location: <u>504</u>	0.00				11/6/8	5		300
Packaging	Memo	0.00							
140 QC	QC21- Final Inspection - Work Order Release	0.00							11/6/9
Quality Control	Memo	0.00							ME 11-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 10:07:40 AM

Page 1

Work Order ID: 69894



Parent Item: D2537



Parent Item Name: Bushing



Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP D05.01.31 Material change on Step 2 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R.500  304 SS roundbar .500		Purchased	No			100	f	23.0600	0.1146 	3.618947			

5/24/11 11:06 AM
3.6

Location	Loc Qty	Loc Code
MAT029	23.06	
115334	23.06	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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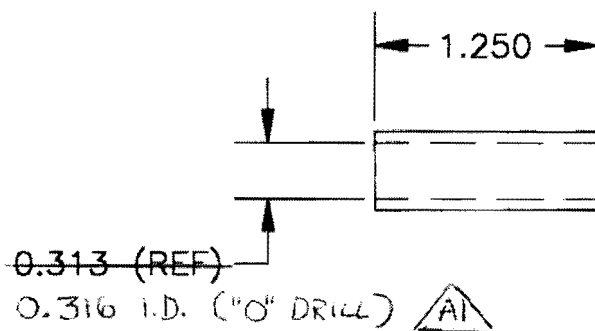
DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED M.M.	APPROVED B.W.	DRAWING NO. D2537	REV. A SHEET 1 OF 1
DATE 96:05:15		TITLE BUSHING	SCALE 1:1
AI	02.08.30 UP QS	0.316 WAS 0.313	

RELEASED
9607/26 BW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69894



PR11-05-24



MATERIAL: 304/316 SS 7/16 OD 0.063 WALL

OR 0.065 WALL

KE 99.09.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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